

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009721**Date Inspected:** 16-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM 16 (BAY 05)

Submerged Arc Welding Process:

Welding of weld joint -001,002 located on PCMK CB202B-016. Welder is identified as 215248. ZPMC QC is identified as Zhen zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # CROSS BEAM 12 (OPEN YARD)

Flux Cored Arc Welding Process:

Welding of weld joint -089,090 located on PCMK CB201G-033. Welder is identified as 069118. ZPMC QC is identified as Sun yan fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -089,090 located on PCMK CB201G-034. Welder is identified as 069118. ZPMC QC is

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

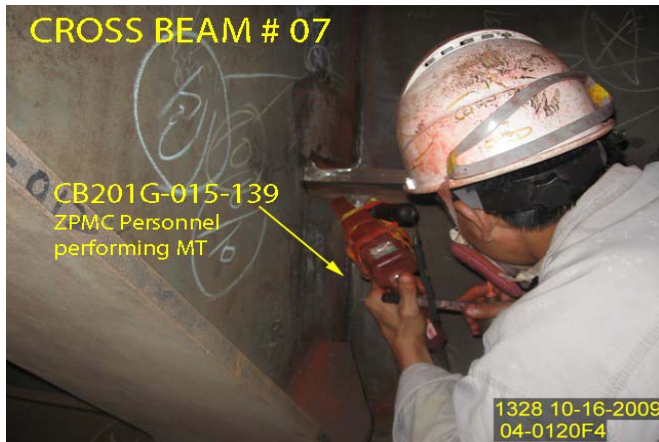
identified as Sun yan fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -089,090 located on PCMK CB201G-035. Welder is identified as 069118. ZPMC QC is identified as Sun yan fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # CROSS BEAM 07 (OPEN YARD)

During in-process visual inspection of the OBG Cross Beam 07 components in Open yard, This QA inspector witnessed that ZPMC MT Technician Mr. Jin jian ting performing magnetic particle testing for the Cross beam components. See attached picture

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
